Monday, 7/9/2007 11:46:55 AM Kim Johnston User: **Process Sheet** : CABIN FLOOR PROTECTOR **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 33356 **Estimate Number** : 12660 : D35741 : N/A Part Number P.O. Number s.o. No. : N/A · D3574 REV.A : 7/9/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : NIA : SMALL /MED FAB **Drawing Revision** First Issue Type : 30475 Material Previous Run : 7/13/2007 Due Date Written By Checked & Approved By New Issue 07-01-22 EC Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 1.0 F60029 lexan grey Comment: Qty.: 16.0000 sf(s)/Unit Total: 48.0000 sf(s) F60029 lexan sheet Batch: M 103106 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev:___ Prog Rev:_ 2-Deburr if necessary 3.0 INSPECT PARTS AS THEY COME OFF MACHINE QC2 1B 07-07-11 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK 5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: AloHi
*				.
3			QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)							
STEP	Description of NC Section A	Section A Initial Action Description Sign &						
4		N	Change DSK's and	Ch &	Sur	04/07/12	Sn	
20	P.L. Wrong DEK.	वाज।2	Scrap and Rapber	57-57-72	stoke	777	Todie	
	4	STEP Description of NC Section A 2 (Names Scrap)	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief Eng Action Description Chief Eng Chief Eng Make fore they eve wright.	STEP Description of NC Section A Initial Chief Eng C	STEP Description of NC Section A Initial Action Description Chief Eng Chief Eng Change DSK's and Make fure they are wright. Corrective Action Section B Verification Section C Section C	STEP Description of NC Section A Initial Chief Eng C	

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:55 AM User: Kim Johnston **Process Sheet** Drawing Name: CABIN FLOOR PROTECTOR Customer: CU-DAR001 Dart Helicopters Services Part Number: D35741 Job Number: 33356 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE W 07.09 13 Job Completion

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W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,
			·					
`Part No	•	PAR #:	Fault Category:	NCR : Ye	s No DQ	A:	_ Date: _	

QA: N/C Closed: _____ Date: ____

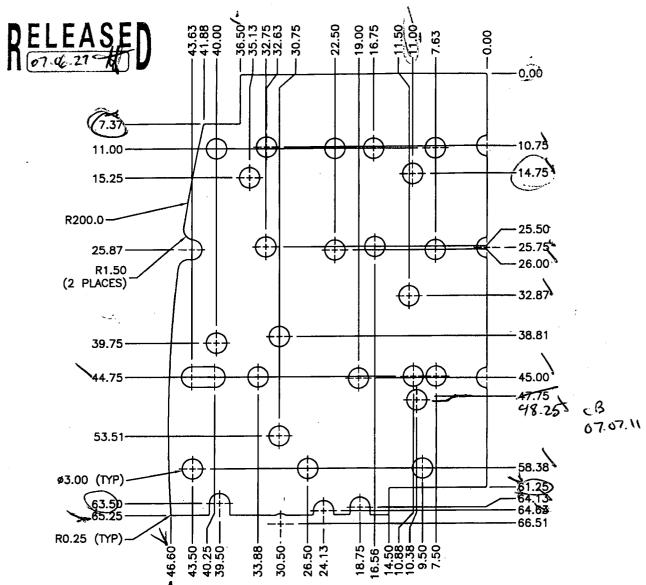
NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annewal	Ammayal	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries



DESIGN	CB	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	_
CHECKED	APPROVED /	DRAWING NO.	REV. A
LE		D3574	SHEET 1 OF 5
DATE		ΠΠLE	SCALE
07.06.08		CABIN FLOOR PROTECTOR	1:14

07.06.08 | NEW ISSUE



Α

D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, SHOP COPY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO
- 2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING

WORK ORDER

4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INKOMARKER LED COPY ON SMOOTH SIDE OF PART WITHOUT NOTICE

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

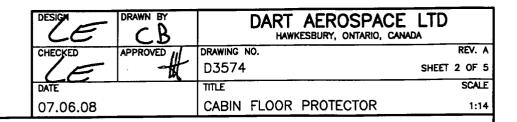
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

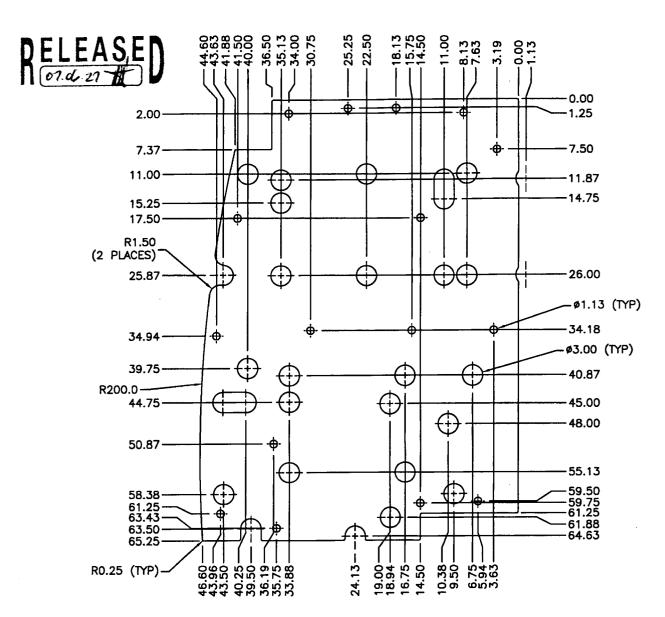
7) CHECK PER TEMPLATE DT8961

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D3574-3 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) SHOP COPY
- 2) FINISH: NONE

RETURN TO

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING

- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT NARKER COPY
 ON SMOOTH SIDE OF PAPT SUBJECT TO AMENDMENT ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

WITHOUT NOTICE

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

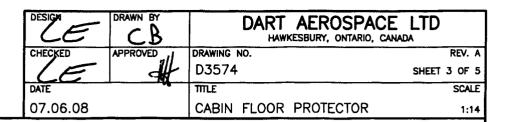
WORK ORDER

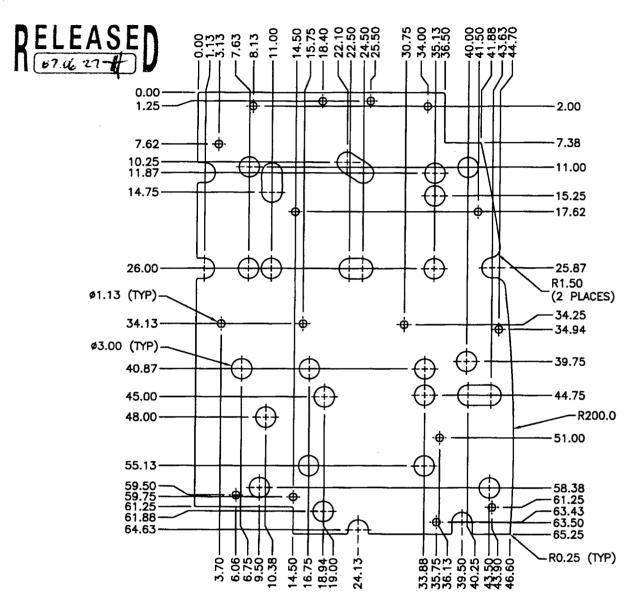
7) CHECK PER TEMPLATE DT8962

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D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THER? COPY RETURN TO TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) ENGINEERING
- 2) FINISH: NONE
- 4) IDENTIFY WITH DART QSI 018 UNLESS OTHERWISE NOTED

 ON SMOOTH SIDE OF PART

 TO SHAPE THE DART QSI 018 UNLESS OTHERWISE NOTED

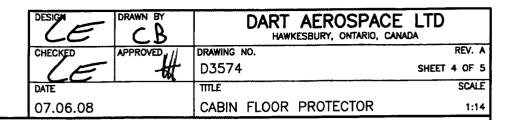
 ON SMOOTH SIDE OF PART

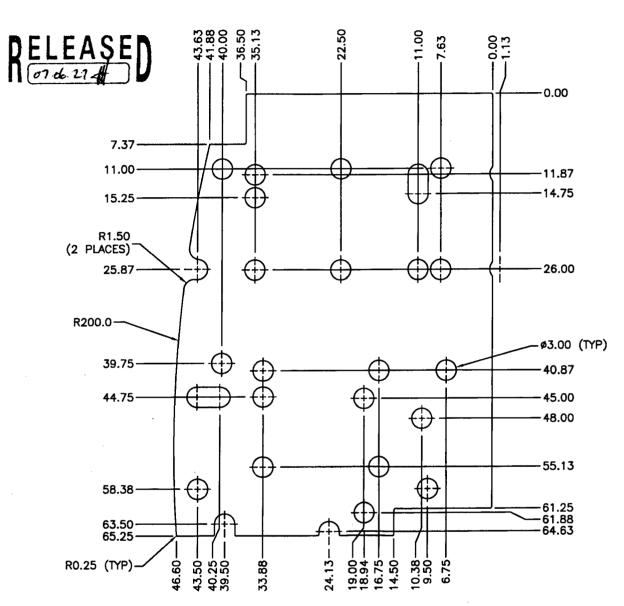
 ON SMOOTH SIDE OF PART WORK ORDER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- CHECK PER TEMPLATE DT8963

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D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)HOP COPY
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT ON SMOOTH SIDE OF PART SUBJECT TO AMENDMENT
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

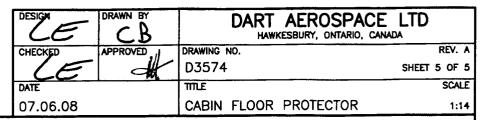
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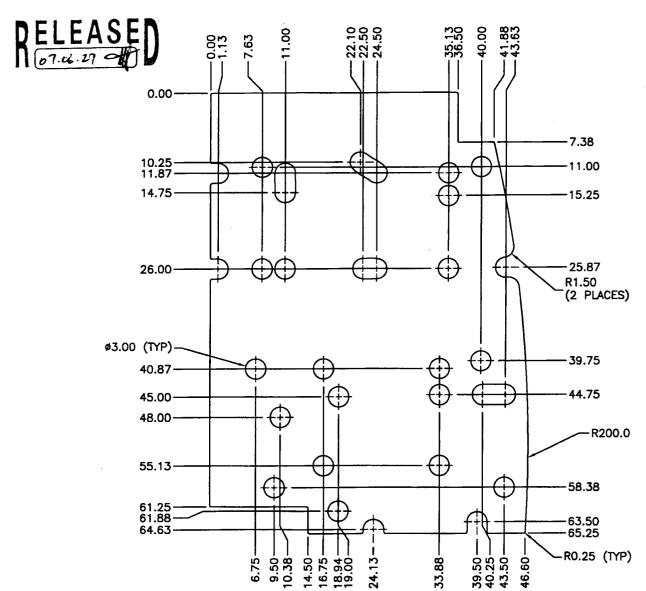
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RETURN TO ENGINEERING

WITHOUT NOTICE WORK ORDER







D3574-6 CABIN FLOOR PROTECTOR

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, SHOP COPY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE

RETURN TO ENGINEERING

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK CMARKERLED COLY ON SMOOTH SIDE OF PART

- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- SUBJECT TO AMENDMEN WITHOUT NOTICE WORK ORDER

- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order:	33386
	floor PROTECTOR	Part Number:	D3574-1
Inspection Dwg:	Rev: A		Page 1 of 1

			FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
				First Artic	cle	Proto	otype	•	
Drav Dime	ving nsion	Tole	erance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
10	.75	₹	030	10.75	*				
14	.75_	4/	030	14.75	*			-	
/ 25	3.75	1 /	. مرکّم	25.75	*				
	S.So	+/_	. 436	25.50	*				
	a00		030	76.00	*				
,	2.27	+/_	,630	32.87	*		,		
	8.81	*/-	.030	38.81	*				
14	\$,60	+/_	.030	4500	*				
	8.35	+/-	-030	ેલ. શુર્ધ	*				
	8:38	H_	موره.	5838	*				
	1.25	+/_	. 030	61.75	*			<u> </u>	
164		+/_	.030	64.13	*			<u> </u>	
	63	+/_	.630	64,63	*			•	
· Will		14/1	Mean	MARKEN	hap				
		8							
			44 11						
		-			1				
					-				
					+	 		-	-
Measu	red by:	退		Audited by:	in	F	rototype App	oroval:	
	Date:	67-07-	- (1	Date:	Doslu			Date:	
Rev	Date	Chang						Revised by	Approved
A	Date	New Is:			,		K	J/RF	

DART AEROSPACE LTD	Work Order:	33356
Description: CABIN Floor PROTECTOR	Part Number:	D3574-1
Inspection Dwg: Rev: A		Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	N CHE	CKLIST		
		First Artic	le	Proto	type	•	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
1 7.37	t/- ,030	7.37	*				
16.00	7030	ll.00	×				
15.25	4/030	26.21	*				
1 25.87	+/030	25.87	*				
/ 39:15	4/030	39.75	#			ļ	
144.78	4- ,030	44.75	*			ļ	
\$3.5 1	4030	53 SI	*				
Ø 3.00	\$ +0012	3,06	*			*	
163.50	1/ 030	63,50	*			-	
ZG.23	4630	26.23	*				
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				-			
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					<u> </u>		
			$\overline{}$		rototype Ap	oroval:	
Measured by:	lb	Audited by:	X	F	Tototype Api	Date:	
Date:	07-07-4	Date:	svali			טמוב.	
Rev Date	Change					Revised by	Approved
A	New Issue				H	(J/RF	

DART AEROSPACE LTD	Work Order:	33356
Description: CABIN FLOOR PROTECTOR	Part Number:	D 3574-
Inspection Dwg: Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		First Artic	le	Proto	type 	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46,60	+/030	46.60	*			
43.50	41030	43.50	*			
40.85	41030	40.25	*	ļ		
39.50	4030	39.50	- *			
33.88	4-,630	33.88	*			
30.50	4/- 1030	30.50	*			
26.50	4/- ,030	26.50	*			
24.13	+/- ,630	24.13	*			3
			1 1	1	1	

39.50	4- 030	39.50	*	ļ	
33.88	4-,630	33.88	*		
30.50	4/- 1030	30.50	*		
26.50	4/- ,030	26.50	*		
24.13	+/630	34.13	*		 <u> </u>
18.75	4/030	18.75	*		
16.56	+/- ,030	16.56	*		
14.50	4/- :030	14.50	*	<u> </u>	
10.88	TL ,030	10.88	×		
10.38	4/- ,030	10.38	*		•
9.50	41- 030	9,50	4		
7.50	t/- c30	7.50	*		
			-		
1	<u></u>				

Measured by: P	Audited by:	Prototype Approval:	
Date: 07-67-11	Date: AlAlu	Date:	

Rev	Date	Change	Revised by	Approved
_ A		New Issue	KJ/RF	

DART AEROSPACE LTD	Work Order:	33356	
Description: CABIN Flow PROTECTOR	Part Number:	D3574-1	
Inspection Dwg: Rev: A		Page 1 of 1	

	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
		First Artic	le _	Proto	otype	•	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
43,63	4030	43.63	*				
41.88	4- 030	41.88	*				
40.66	+1030	40.00	*				
36,50	4/030	36.50	*				
35,13	4030	35.13	_*				
32.75	4/030	35.75	*				
32.63	+/030	37.63	*				
30,75	1/2 .030	30.75	*				····
39.50	4/- ,030	32.50	*				
19.00	4030	19.00	*				
16.75	4030	16.75	*	ļ			
11.50	+/030	11.50	K				
(1.00	+/030	11.00	*			•	
7.63	1/030	763					
		-		 			
				-		a a	
			<u> </u>	1			
Measured by:	10	Audited by:		F	Prototype Appro	oval:	
Date:	B 57-57-11	Date: 0	Hozli			Date:	
Rev Date	Change		<u>-</u>			vised by	Approved
A Date	New Issue				KJ/	RF	